

Work Order ID 67135

Wednesday, March 09, 2011 10:35:36 AM

Page 1

Item ID: D135-751-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube Installation

Start Date: 3/9/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3507

Rev C

100

0.00

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

8 u/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut Aft end as per dwg D3507

2-Deburr ends

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

4-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill.*****DO NOT OPEN AFT CAP HOLES*****

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892.Open holes to 0.297"

9-Open Aft & Fwd Cap holes using .208" drill. *Detail B+F*

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Open ground wire hole .297" section E-E

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

1 0 BEI/C3/15

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/11/03/15



150

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1

BB 11/03/15

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



11-3-15

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507.
and Detail "F" open holes Section 6-6 as per Dwg D3507

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & OSI 015

A/R 241 Sike Flex Batch: 116040
Exp Date: 11/09/30
start time: 3:20
end time: 4:00

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: 111385

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using D1887 A&B

8-Deburr Rivet holes.

BB

11/03/15

BE 11/03/16

BE 11/03/17

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/11/03/17



190

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Rivet D3506-1/-3 as per Dwg D3507.

1 0 BE11/03/17

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/03/17



Dart Aerospace Ltd

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 BR 11-3-18

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M115951

Memo

0.00

Powder Coating

START TIME: 11:30
OVEN TEMPERATURE: 320°
FINISH TIME: 12:00

1 BR 11-3-18

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 φ 11/03/21

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240



HandFinish

Hand Finishing

HandFinishing

Memo

✓ Install Wearplate & Ground Wire inserts as per Dwg D3507.

0.00

0.00

1 6 M 11/03/22

250



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Inspect Inserts

0.00

0.00

Subtotal

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

✓ 1-Inspect for Foreign objects

✓ 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: M116040
Exp Date: 11/09

✓ 3-Install Wearplates as per Dwg D3507 ,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Screws where indicated on Dwg (Note #6)

✓ A/R 241 Sika Flex Batch: M116040
Exp Date: 11/09

✓ 4-Install Plug assemblies with lubricate as per Dwg D3507.

Batch: M114189

✓ 5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Batch: M1160402

1 0 21 11/03/22

270



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S. W. M.

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

4/13/22 (1)

290



QC

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Quality Control

8/10/22

(X)

300



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D135-751-011

Location: _____

PPP Rev: *B**11/13/22*

W/O:		WORK ORDER CHANGES						
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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

310

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/22 JG

MF

11-03-22

Picklist Print

Wednesday, March 09, 2011 10:35:32 AM

Page 1

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Parent Item: D135-751-011

Parent Item Name: Skidtube Installation




Start Date: 3/9/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 06-06-21 New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verified DD
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F
 10.06.09 remove seq110 DD ver:EC IPP Rev G 10.09.17
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3507-1-BENT  Skidtube Assembly EC135		Manufactured	No			120	Each	2.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				2					
					62291			1					
					62292			1					
D3504-1  Crossbolt Spacer		Manufactured	No			170	Each	18.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				18					
					53742			18					
D3504-3  Crossbolt Spacer		Manufactured	No			170	Each	30.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				30					
					31232			10					
					53743			20					

BEN 3/14
 67132 x1

BEN 03/16

BEN 03/16

1

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Start Date: 3/9/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3504-5 Manufactured No

170 Each

18.0000

2 2



Crossbolt Spacer



BE 11/03/16

Location

Loc Qty

Loc Code

LG

18

36181

2

53744

16

D3505-1

Manufactured No

170 Each

0.0000

1 1



Web

D3506-1

Manufactured No

190 Each

70.0000

4 4



Doubler



BE 11/03/17

Location

Loc Qty

Loc Code

ST063

70

51789

70

D3506-3

Manufactured No

190 Each

66.0000

2 2



Doubler



BE 11/03/17

Location

Loc Qty

Loc Code

ST063

66

51790

66

MS20601-AD4W3

Purchased No

190 Each

3,523.000

12 12



Rivet



BE 11/03/17

Location

Loc Qty

Loc Code

ST321

3523

114538

3523

12

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Start Date: 3/9/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

240

Each

1,538.000

38

38



Insert



38 4/03/21

Location

Loc Qty

Loc Code

FP

21

115079

21

ST282

1517

113238

17

115502

500

116800

1000

x38
x4

ALS4-1032-225

Purchased

No

260

Each

3,809.000

1

1



Insert



31 11/03/22

Location

Loc Qty

Loc Code

PK011

3809

110768

3809

x1

AN3C4A

Purchased

No

260

Each

2,161.000

31

31



BOLT



31 11/03/22

Location

Loc Qty

Loc Code

ST350

2161

115300

25

116075

337

116704

114

116924

1200

117010

485

x31

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Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No

260

Each

1,008.000

2

2



Ysl 11/03/22

Bolt

Location

Loc Qty

Loc Code

ST350

1008

107862

68

108302

34

114330

11

115015

13

115371

4

115422

100

115835

178

116419

500

116549

100

Y2

AN526C1032R10 Purchased No

260

Each

390.0000

2

2



Ysl 11/03/22

Screw

Location

Loc Qty

Loc Code

ST327

100

114494

100

ST328

290

108062

126

110049

164

X2

AN960C10L NAS1149C0332 Purchased No

260

Each

61.0000

33

33

R



Ysl 11/03/22

washer

Location

Loc Qty

Loc Code

ST297

61

107534

59

108246

2

M116304

Y33

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 10:35:33 AM

Work Order ID: 67135

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/9/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D2965 Manufactured No 260 Each 35.0000 1 1



Cap, 105 Skidtube



HL 11/03/22

Location

Loc Qty

Loc Code

FP4

35

52057

35

Y1

D2965-3 Manufactured No 260 Each 7.0000 1 1



Cap



HL 11/03/22

Location

Loc Qty

Loc Code

FP

7

50560

3

52282

4

Y1

D3492-041 Manufactured No 260 Each 77.0000 4 4



Plug Assembly



HL 11/03/22

Location

Loc Qty

Loc Code

FP013

77

59114

1

62210

3

63994

29

65068

44

Y4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 10:35:33 AM

Work Order ID: 67135

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/9/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-043

Manufactured No

260

Each

125.0000

4

4



Plug Assembly



11/03/22

Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

123

59117

1

59190

4

63996

2

65070

16

66150

20

66931

80

X4

D3492-047

Manufactured No

260

Each

37.0000

2

2



Plug Assembly



11/03/22

Location

Loc Qty

Loc Code

FP

37

28961

26

39722

11

V2

D3508-1

Manufactured No

260

Each

19.0000

1

1



Wearplate



11/03/22

Location

Loc Qty

Loc Code

FP

5

42973

1

51261

4

X1

FP-16

14

61020

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 10:35:33 AM

Page 7

Work Order ID: 67135



Parent Item: D135-751-011



Parent Item Name: Skidtube Installation

Start Date: 3/9/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3508-3	Manufactured	No	260	Each	8.0000	1	1
							3/11/03/22
Wearplate							

Location	Loc Qty	Loc Code
FP	1	
38527	1	
FP21	7	
62882	1	
65192	6	

D3508-5	Manufactured	No	260	Each	5.0000	1	1
							3/11/03/22
Wearplate							

Location	Loc Qty	Loc Code
FP	1	
42251	1	
FP21	4	
51388	4	

D3508-7	Manufactured	No	260	Each	3.0000	1	1
							3/11/03/22
Wearplate							

Location	Loc Qty	Loc Code
FP	1	
31198	1	
FP21	2	
60336	2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 10:35:33 AM

Page 8

Work Order ID: 67135

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/9/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3558-1

Manufactured No

260

Each

16.0000

1

1



Gasket



xl 11/03/22

Location

Loc Qty

Loc Code

FP

16

42533

1

50925

15

D3558-3

Manufactured No

260

Each

6.0000

1

1



Gasket



xl 11/03/22

Location

Loc Qty

Loc Code

FP

6

42253

1

55468

5

D3558-5

Manufactured No

260

Each

6.0000

1

1



Gasket



xl 11/03/22

Location

Loc Qty

Loc Code

FP

6

43244

1

50926

5

D3558-7

Manufactured No

260

Each

3.0000

1

1



Gasket



xl 11/03/22

Location

Loc Qty

Loc Code

FP

3

43245

1

50927

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 10:35:33 AM

Page 9

Work Order ID: 67135

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/9/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-007

Purchased

No

260

Each

440.0000

2

2



HL 11/03/22

O-RING

Location

Loc Qty

Loc Code

FP

440

103697

440

X2

NAS1611-010

Purchased

No

260

Each

309.0000

4

4



HL 11/03/22

O-RING

Location

Loc Qty

Loc Code

FP

309

110715

100

110915

159

115589

50

X4

NAS1611-013

Purchased

No

260

Each

243.0000

4

4



HL 11/03/22

O-RING

Location

Loc Qty

Loc Code

FP

243

115460

100

115589

28

115812

20

116582

95

X4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 10:35:33 AM

Work Order ID: 67135

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/9/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

280

Each

2,161.000

8

8



BOLT

Location

Loc Qty

Loc Code

ST350

2161

115300

25

116075

337

116704

114

116924

1200

117010

485

116929

AN960C10L

NAS1149C0332

Purchased

No

280

Each

61.0000

8

8



washer

Location

Loc Qty

Loc Code

ST297

61

107534

59

108246

2

D3512-1

Manufactured

No

280

Each

1.0000

2

2



Wearplate

Location

Loc Qty

Loc Code

ST500

1

63954

1

67169 11/3/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20801AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

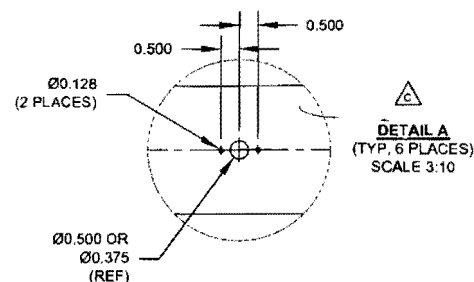
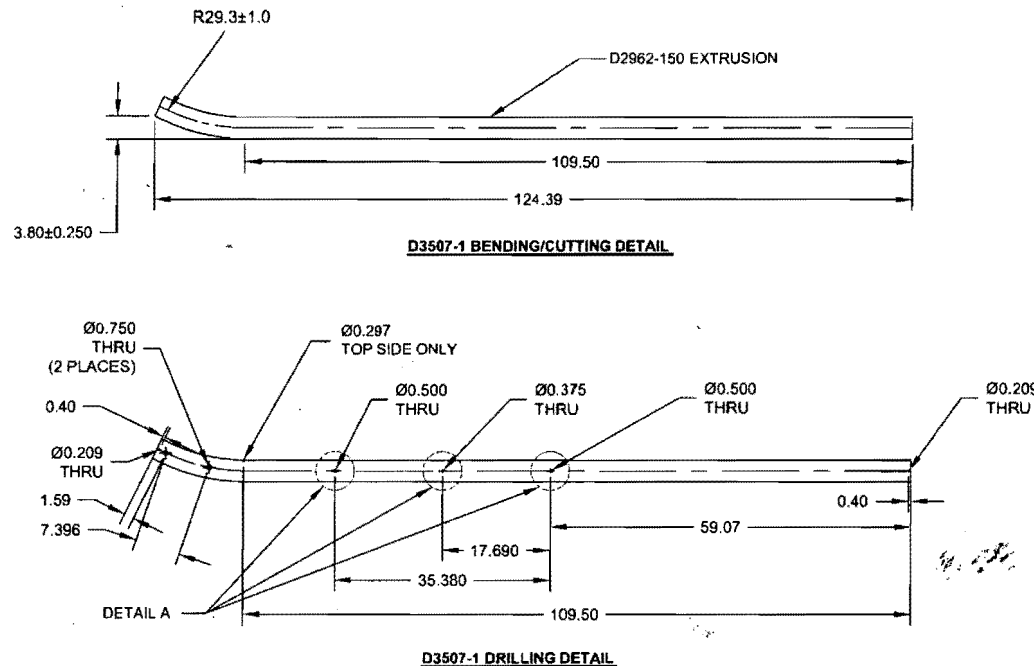
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	05.11.01
A	NEW ISSUE	BH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	JC		
CHECKED	RA		
MFG. APPR.	EP		
APPROVED	JP		
DE APPR.			
DATE	07.09.19		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

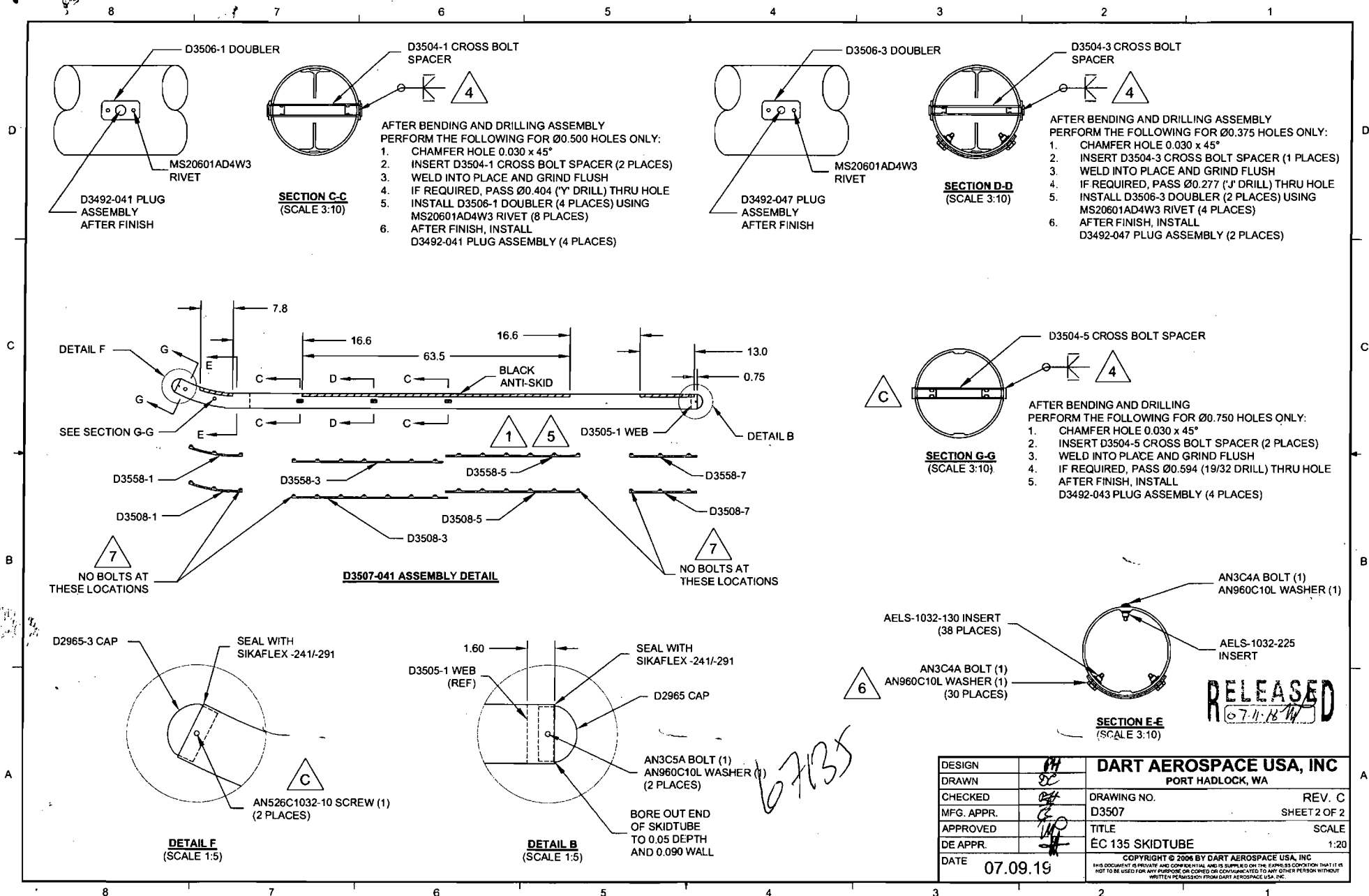
DRAWING NO. **D3507** REV. C
SHEET 1 OF 2

TITLE **EC 135 SKIDTUBE** SCALE **NTS**

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W6 67135



NO. 247

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 66661
Part number: D135-751-011
Description: 135 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[] fail[]

Qualifier Pat Jones Date of Test Coupon 11/03/17
Welder Barclay Elliot Date of Test Coupon 11/03/17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld